IN THE CLAIMS

Please amend the claims as follows:

Claims 1-58 (Canceled).

Claim 59 (Currently Amended): A radioactive substance container comprising a thick bottomed container, wherein ~~in which~~

a bottom section and a body section of the thick bottomed container are formed integrally by hot-dilating a metal billet in a container for forming, wherein sections of inner and outer circumferences of the thick bottomed container vertical to an axial direction of the thick bottomed container are octagonal.

Claim 60 (Currently Amended): The radioactive substance container according to claim 59, ~~wherein a section of the metal billet vertical to an axial direction is polygonal and a shape in a section of the container for forming vertical to an axial direction is circular~~, wherein the inner circumference of the thick bottomed container vertical to the axial direction of the bottomed container has an irregular octagonal shape which is modified from rectangular shape by chamfering four corners of the rectangular shape.

Claim 61 (Currently Amended): A radioactive substance container comprising a thick bottomed container, wherein a bottom section and a body section of the thick bottomed container are formed integrally by hot-dilating a metal billet in a container for forming, wherein inner circumference of the bottomed container vertical to an axial direction of the bottomed container is polygonal, wherein the polygonal is defined as a modified shape of rectangular by shaping each of the four corners of the rectangular shape having at least a

step~~The radioactive substance container according to claim 59, wherein a section of the metal billet vertical to an axial direction is polygonal and a section of the container for forming vertical to an axial direction is polygonal~~.

Claim 62 (Canceled).

Claim 63 (Previously Presented): The radioactive substance container according to claim 59, wherein an outer diameter of the bottomed container is not less than 1000 mm to not more than 3000 mm and its thickness is not less than 150 mm to not more than 300 mm.

Claim 64 (Previously Presented): The radioactive substance container according to claim 59, wherein a spot facing section is further formed integrally with the bottom section at the time of forming the bottomed container.

Claim 65 (Previously Presented): The radioactive substance container according to claim 59, wherein a flange is further provided integrally with the body section of the bottomed container.

Claim 66 (Canceled).

Claim 67 (Currently Amended): A radioactive substance container comprising:

a thick bottomed container, wherein ~~in which~~ when

a metal billet is hot-dilated in a container for forming one end of the metal billet is left not hot-dilated ~~and its body section is worked, a boring uncompleted section remains on one end side of the body section~~ so as to be a bottom section, wherein ~~and~~ the bottom section and

the body section are formed integrally, wherein sections of inner and outer circumferences of the bottomed container vertical to an axial direction of the bottomed container are octagonal.

Claims 68-70 (Canceled).

Claim 71 (Previously Presented): The radioactive substance container according to claim 67, wherein an outer diameter of the bottomed container is not less than 1000 mm to not more than 3000 mm and its thickness is not less than 150 mm to not more than 300 mm.

Claim 72 (Previously Presented): The radioactive substance container according to claim 67, wherein a spot facing section is further formed integrally with the bottom section at the time of forming the bottomed container.

Claim 73 (Previously Presented): The radioactive substance container according to claim 67, wherein a flange is further provided integrally with the body section of the bottomed container.

Claim 74 (Previously Presented): The radioactive substance container according to claim 67, wherein at least any one of an external section and an internal section of the bottomed container vertical to the axial direction is polygonal.

Claim 75 (Currently Amended): A radioactive substance container comprising:

a bottomed container for storing a basket for used nuclear fuel aggregate, wherein ~~in which~~ a bottom section and a body section of the bottomed container are formed in one piece ~~is integral~~ by hot dilation forming in a container for forming, wherein sections of

inner and outer circumferences of the bottomed container vertical to an axial direction of the bottomed container are octagonal.

Claim 76 (Canceled).

Claim 77 (Previously Presented): The radioactive substance container according to claim 75, wherein a spot facing section is further formed integrally with the bottom section at the time of forming the bottomed container.

Claim 78 (Previously Presented): The radioactive substance container according to claim 75, wherein a flange is further provided integrally with the body section of the bottomed container.

Claim 79 (Currently Amended): The radioactive substance container according to claim 75, wherein at least any one of sections of inner and outer circumferences ~~an external section and an internal section~~ of the bottomed container vertical to the axial direction is ~~polygonal~~ octagonal.

Claim 80 (Currently Amended): A radioactive substance container comprising a bottomed container, ~~in which~~ wherein a dosage equivalent factor of γ rays on an outer wall surface of a substantially center portion of a side surface of the body is not more than 200 μSv/h in the case where radioactive substance is contained in a bottomed container, wherein ~~in which its~~ bottom section and body section of the bottomed container are formed integrally by hot dilation forming in a container for forming, wherein sections of inner and outer

circumferences of the bottomed container vertical to an axial direction of the bottomed container are octagonal.

Claim 81 (Previously Presented): The radioactive substance container according to claim 80, wherein a spot facing section is further formed integrally with the bottom section at the time of forming the bottomed container.

Claim 82 (Previously Presented): The radioactive substance container according to claim 80, wherein a flange is further provided integrally with the body section of the bottomed container.

Claims 83-87 (Canceled).

Claim 88 (Withdrawn): A radioactive substance container comprising:

a bottomed container where a bottom section and a body section are formed integrally by hot press pressure and γ rays generated from radioactive substance such as used fuel is shielded;

a neutron shielding member which is provided around the bottomed container and shields neutron generated from the radioactive substance; and

a cover for covering an opening of the bottomed container.

Claim 89 (Withdrawn): The radioactive substance container according to claim 88, wherein a spot facing section is further formed integrally with the bottom section at the time of forming the bottomed container.

Claim 90 (Withdrawn): The radioactive substance container according to claim 88, wherein a flange is further provided integrally with the body section of the bottomed container.

Claim 91 (Withdrawn): The radioactive substance container according to claim 88, wherein at least any one of an external section and an internal section of the bottomed container vertical to the axial direction is polygonal.

Claim 92 (Withdrawn): A radioactive substance container comprising:

a bottomed container which contains a radioactive substance such as used fuel into a body section with a bottom section and shields γ rays generated from the radioactive substance;

a neutron shielding material which is arranged around the bottomed container and shields neutron generated from the radioactive substance,

wherein a metal billet is heated and is upset and drawn so that the bottom section and the body section are formed integrally.

Claim 93 (Withdrawn): The radioactive substance container according to claim 92, wherein a spot facing section is further formed integrally with the bottom section at the time of forming the bottomed container.

Claim 94 (Withdrawn): The radioactive substance container according to claim 92, wherein a flange is further provided integrally with the body section of the bottomed container.

Claim 95 (Withdrawn): The radioactive substance container according to claim 92, wherein at least any one of an external section and an internal section of the bottomed container vertical to the axial direction is polygonal.

Claim 96 (Withdrawn): A hot dilation forming-use metal billet, wherein at least a section vertical to an axial direction on a pressing forward side is formed into a polygonal shape.

Claim 97 (Withdrawn): The billet according to claim 96, wherein a taper which becomes thinner towards the pressing direction is provided on the pressing forward side of the metal billet.

Claim 98 (Withdrawn): The billet according to claim 96, wherein at least one or more stepped sections are provided so that the pressing forward side of the metal billet becomes thinner gradationally towards the pressing direction.

Claim 99 (Withdrawn): A hot dilation forming-use metal billet, wherein at least one plane is provided on at least any one of a side surface on a pressing forward side and a side surface on a pressing backward side.

Claim 100 (Withdrawn): The billet according to claim 99, wherein a taper which becomes thinner towards the pressing direction is provided on the pressing forward side of the metal billet.

Claim 101 (Withdrawn): The billet according to claim 99, wherein at least one or more stepped sections are provided so that the pressing forward side of the metal billet becomes thinner gradationally towards the pressing direction.

Claim 102 (Withdrawn): A hot dilation forming-use metal billet, wherein at least one plane is provided on a side surface and an extended section which engages with an end portion of an inlet of a container for forming is provided on an end portion on a pressing backward side.

Claim 103 (Withdrawn): A hot dilation forming-use metal billet, wherein at least a section vertical to an axial direction on a pressing forward side is formed into a polygonal shape, and an extended section which engages with an end portion of an inlet of a container for forming is provided on a pressing backward side.

Claim 104 (Withdrawn): A hot dilation forming-use metal billet, wherein at least a section vertical to an axial direction on a pressing forward side is formed into a polygonal shape, and at least one or more stepped sections are provided so that the pressing forward side becomes thinner gradationally towards a pressing direction, and an extended section which engages with an end portion of an inlet of a container for forming is provided on a pressing backward side.

Claim 105 (Withdrawn): A hot dilation forming-use metal billet, wherein at least one plane is provided on at least any one of a side surface on a pressing forward side and a side surface on a pressing backward side, and at least one or more stepped sections are provided so that the pressing forward side becomes thinner gradationally towards the pressing

direction, and an extended section which engages with an end portion of an inlet of a container for forming is provided on the pressing backward side.

Claim 106 (Currently Amended): A container, wherein a metal billet is hot-dilated in a container for forming, and a bottom section and body section are formed integrally and a thick bottomed container is obtained wherein sections of inner and outer circumferences of the thick bottomed container vertical to an axial direction of the thick bottomed container are octagonal.

Claims 107-108 (Canceled).

Claim 109 (Previously Presented): The container according to claim 106, wherein an outer diameter of the bottomed container is not less than 200 mm to not more than 4000 mm, and a thickness is not less than 20 mm to not more than 400 mm.

Claim 110 (Currently Amended): The container according to claim 106, wherein the bottomed container is constituted so that at least any one of an external section and an internal section of the bottomed container vertical to the axial direction is octagonal ~~polygonal~~.

Claim 111 (Currently Amended): A container, wherein when

a metal billet is hot-dilated in a container for forming and a body section is worked, ~~a boring uncompleted section is allowed to remain on one end side of the body section so as to be a bottom section, and an integrally thick bottomed container is obtained~~

one end of the metal billet is left not hot-dilated so as to be a bottom section, wherein the bottom section and the body section are formed integrally, wherein sections of inner and outer circumferences of the container vertical to an axial direction of the container are octagonal.

Claims 112-113 (Canceled).

Claim 114 (Previously Presented): The container according to claim 111, wherein an outer diameter of the bottomed container is not less than 200 mm to not more than 4000 mm, and a thickness is not less than 20 mm to not more than 400 mm.

Claim 115 (Canceled).

Claim 116 (Currently Amended): A container, wherein a metal billet, where at least a section vertical to an axial direction on a pressing forward side is octagonal ~~polygonal~~, is set into a container for forming, and a boring punch is pushed into the metal billet and the metal billet is hot-dilated to be formed into a bottomed container where a bottom section and a body section are integral, wherein the bottomed container is constituted so an external section of the bottomed container vertical to the axial direction is octagonal.

Claim 117 (Canceled).

Claim 118 (Withdrawn): A bottomed container manufacturing apparatus comprising:

a container for forming having at least a container body section and a container bottom section in which the container body section and the container bottom section can move relatively with respect to an axial direction of the container body section; and

a boring punch which is mounted to a pressing machine and pressurizes a metal billet for hot dilation forming set into the container for forming.

Claim 119 (Withdrawn): A bottomed container manufacturing apparatus comprising:

a container for forming having at least container body sections and container bottom sections divided in an axial direction in which the container body section and the container bottom section can move relatively with respect to an axial direction of the container body section; and

a boring punch which is mounted to a pressing machine and pressurizes a metal billet for hot dilation forming set into the container for forming.

Claim 120 (Withdrawn): A radioactive substance container manufacturing method comprising:

the step of rounding a drum-shaped bottomed container where a bottom section and a body section are formed integrally by hot dilation and setting a tool so as to cut an external side of the bottomed container; and

the step of cutting an internal section of the bottomed container into a shape according to at least one portion of an outer peripheral shape of a basket for containing used nuclear fuel aggregate.

Claim 121 (Withdrawn): A radioactive substance container manufacturing method comprising:

the step of hot-dilating a bottomed container so that its bottom section and body section are integral; and

the step of cutting an internal section of the bottomed container into a shape according to at least one portion of an outer peripheral shape of a basket for containing used nuclear fuel aggregate.

Claim 122 (Withdrawn): A container manufacturing method comprising:

the step of setting a metal billet having at least one plane on a side surface into a container for forming with a gap from an inner wall; and

the step of pushing a boring punch into the metal billet and bending the plane towards the inner wall so as to hot-dilate the metal billet.

Claim 123 (Withdrawn): The method of manufacturing a container according to claim 122, further comprising the step of forming the metal billet by means of a forging step and forming at least the pressing forward side of the metal billet into an angular section.

Claim 124 (Withdrawn): The method of manufacturing a container according to claim 123, wherein the forging step includes the step of providing a taper which becomes thinner towards the pressing direction on the pressing forward side of the metal billet.

Claim 125 (Withdrawn): The method of manufacturing a container according to claim 123, wherein the forging step includes the step of providing at least one stepped section so that the pressing forward side of the metal billet becomes thinner gradationally towards the pressing direction.

Claim 126 (Withdrawn): The method of manufacturing a container according to claim 122, further comprising:

the step of providing a drum-shaped member between the metal billet and the bottom of the container for forming and setting the metal billet into the container for forming;

the step of pushing the boring punch into the metal billet and hot-dilating the metal billet so as to form the bottomed container where the bottom section and the body section are integral;

the step of removing the drum-shaped member from the bottom section of the bottomed container after the forming; and

the step of removing a pillar-shaped portion formed on the bottom section of the bottomed container by means of the drum-shaped member.

Claim 127 (Withdrawn): The method of manufacturing a container according to claim 122, further comprising:

the step of providing a pillar-shaped member between the metal billet and the bottom of the container for forming and setting the metal billet into the container for forming;

the step of pushing the boring punch into the metal billet and hot-dilating the metal billet so as to form the bottomed container where the bottom section and the body section are integral; and

the step of removing the pillar-shaped member from the bottom section of the bottomed container after the forming.

Claim 128 (Withdrawn): The method of manufacturing a container according to claim 122, wherein the body section of the container for forming can move relatively with respect to the bottom section of the container for forming.

Claim 129 (Withdrawn): The method of manufacturing a container according to claim 128, wherein the body section of the container for forming is divided in an axial direction.

Claim 130 (Withdrawn): A container manufacturing method comprising:

the step of setting a metal billet, which has at least one plane on a side surface and an extended section engaging with an end portion of an inlet of a container for forming on an end portion of a pressing backward side, into the container for forming with a gap from an inner wall; and

the step of pushing a boring punch into the metal billet and bending the plane towards the inner wall so as to hot-dilate the metal billet.

Claim 131 (Withdrawn): The method of manufacturing a container according to claim 130, further comprising the step of forming the metal billet by means of a forging step and forming at least the pressing forward side of the metal billet into an angular section.

Claim 132 (Withdrawn): The method of manufacturing a container according to claim 131, wherein the forging step includes the step of providing a taper which becomes thinner towards the pressing direction on the pressing forward side of the metal billet.

Claim 133 (Withdrawn): The method of manufacturing a container according to claim 131, wherein the forging step includes the step of providing at least one stepped section so that the pressing forward side of the metal billet becomes thinner gradationally towards the pressing direction.

Claim 134 (Withdrawn): The method of manufacturing a container according to claim 130, further comprising:

the step of providing a drum-shaped member between the metal billet and the bottom of the container for forming and setting the metal billet into the container for forming;

the step of pushing the boring punch into the metal billet and hot-dilating the metal billet so as to form the bottomed container where the bottom section and the body section are integral;

the step of removing the drum-shaped member from the bottom section of the bottomed container after the forming; and

the step of removing a pillar-shaped portion formed on the bottom section of the bottomed container by means of the drum-shaped member.

Claim 135 (Withdrawn): The method of manufacturing a container according to claim 130, further comprising:

the step of providing a pillar-shaped member between the metal billet and the bottom of the container for forming and setting the metal billet into the container for forming;

the step of pushing the boring punch into the metal billet and hot-dilating the metal billet so as to form the bottomed container where the bottom section and the body section are integral; and

the step of removing the pillar-shaped member from the bottom section of the bottomed container after the forming.

Claim 136 (Withdrawn): The method of manufacturing a container according to claim 130, wherein the body section of the container for forming can move relatively with respect to the bottom section of the container for forming.

Claim 137 (Withdrawn): The method of manufacturing a container according to claim 136, wherein the body section of the container for forming is divided in an axial direction.

Claim 138 (Withdrawn): A container manufacturing method comprising:

the step of setting a metal billet, where at least a section vertical to an axial direction on a pressing forward side is formed into a polygonal shape, into a container for forming; and

the step of pushing a boring punch into the metal billet and hot-dilating the metal billet.

Claim 139 (Withdrawn): The method of manufacturing a container according to claim 138, further comprising the step of forming the metal billet by means of a forging step and forming at least the pressing forward side of the metal billet into an angular section.

Claim 140 (Withdrawn): The method of manufacturing a container according to claim 139, wherein the forging step includes the step of providing a taper which becomes thinner towards the pressing direction on the pressing forward side of the metal billet.

Claim 141 (Withdrawn): The method of manufacturing a container according to claim 139, wherein the forging step includes the step of providing at least one stepped section

so that the pressing forward side of the metal billet becomes thinner gradationally towards the pressing direction.

Claim 142 (Withdrawn): The method of manufacturing a container according to claim 138, further comprising:

the step of providing a drum-shaped member between the metal billet and the bottom of the container for forming and setting the metal billet into the container for forming;

the step of pushing the boring punch into the metal billet and hot-dilating the metal billet so as to form the bottomed container where the bottom section and the body section are integral;

the step of removing the drum-shaped member from the bottom section of the bottomed container after the forming; and

the step of removing a pillar-shaped portion formed on the bottom section of the bottomed container by means of the drum-shaped member.

Claim 143 (Withdrawn): The method of manufacturing a container according to claim 138, further comprising:

the step of providing a pillar-shaped member between the metal billet and the bottom of the container for forming and setting the metal billet into the container for forming;

the step of pushing the boring punch into the metal billet and hot-dilating the metal billet so as to form the bottomed container where the bottom section and the body section are integral; and

the step of removing the pillar-shaped member from the bottom section of the bottomed container after the forming.

Claim 144 (Withdrawn): The method of manufacturing a container according to claim 138, wherein the body section of the container for forming can move relatively with respect to the bottom section of the container for forming.

Claim 145 (Withdrawn): The method of manufacturing a container according to claim 144, wherein the body section of the container for forming is divided in an axial direction.

Claim 146 (Withdrawn): A container manufacturing method, wherein a metal billet having at least one plane on at least any one of a side surface on a pressing forward side and a side on a pressing backward side is set into a container for forming, and a boring punch is pushed into the metal billet and the metal billet is hot-dilated.

Claim 147 (Withdrawn): The method of manufacturing a container according to claim 146, further comprising the step of forming the metal billet by means of a forging step and forming at least the pressing forward side of the metal billet into an angular section.

Claim 148 (Withdrawn): The method of manufacturing a container according to claim 147, wherein the forging step includes the step of providing a taper which becomes thinner towards the pressing direction on the pressing forward side of the metal billet.

Claim 149 (Withdrawn): The method of manufacturing a container according to claim 147, wherein the forging step includes the step of providing at least one stepped section so that the pressing forward side of the metal billet becomes thinner gradationally towards the pressing direction.

Claim 150 (Withdrawn): The method of manufacturing a container according to claim 146, further comprising:

the step of providing a drum-shaped member between the metal billet and the bottom of the container for forming and setting the metal billet into the container for forming;

the step of pushing the boring punch into the metal billet and hot-dilating the metal billet so as to form the bottomed container where the bottom section and the body section are integral;

the step of removing the drum-shaped member from the bottom section of the bottomed container after the forming; and

the step of removing a pillar-shaped portion formed on the bottom section of the bottomed container by means of the drum-shaped member.

Claim 151 (Withdrawn): The method of manufacturing a container according to claim 146, further comprising:

the step of providing a pillar-shaped member between the metal billet and the bottom of the container for forming and setting the metal billet into the container for forming;

the step of pushing the boring punch into the metal billet and hot-dilating the metal billet so as to form the bottomed container where the bottom section and the body section are integral; and

the step of removing the pillar-shaped member from the bottom section of the bottomed container after the forming.

Claim 152 (Withdrawn): The method of manufacturing a container according to claim 146, wherein the body section of the container for forming can move relatively with respect to the bottom section of the container for forming.

Claim 153 (Withdrawn): The method of manufacturing a container according to claim 152, wherein the body section of the container for forming is divided in an axial direction.

Claim 154 (Withdrawn): A hot pressing method, of manufacturing a thick metal-made drum or a cylindrical container having an excellent shape of an end surface, wherein a metal billet having different diameter sections without joint, where its pressing forward side is composed of a member having a section with an outer diameter smaller than an inner diameter of a container or an outer diameter of a diagonal length or a member having a section with an outer diameter of a diagonal length equal with the inner diameter of the container and its backward side is composed of a member having a section with an outer diameter or a diagonal length equal with the inner diameter of the container, is set into the container for press forming which was heated to a press working temperature, and while a center of a workpiece of the metal billet without joint is being bored by a punch, the metal billet is press-worked.

Claim 155 (Withdrawn): The method of manufacturing a container according to claim 154, further comprising the step of forming the metal billet by means of a forging step and forming at least the pressing forward side of the metal billet into an angular section.

Claim 156 (Withdrawn): The method of manufacturing a container according to claim 155, wherein the forging step includes the step of providing a taper which becomes thinner towards the pressing direction on the pressing forward side of the metal billet.

Claim 157 (Withdrawn): The method of manufacturing a container according to claim 155, wherein the forging step includes the step of providing at least one stepped section so that the pressing forward side of the metal billet becomes thinner gradationally towards the pressing direction.

Claim 158 (Withdrawn): The method of manufacturing a container according to claim 154, further comprising:

the step of providing a drum-shaped member between the metal billet and the bottom of the container for forming and setting the metal billet into the container for forming;

the step of pushing the boring punch into the metal billet and hot-dilating the metal billet so as to form the bottomed container where the bottom section and the body section are integral;

the step of removing the drum-shaped member from the bottom section of the bottomed container after the forming; and

the step of removing a pillar-shaped portion formed on the bottom section of the bottomed container by means of the drum-shaped member.

Claim 159 (Withdrawn): The method of manufacturing a container according to claim 154, further comprising:

the step of providing a pillar-shaped member between the metal billet and the bottom of the container for forming and setting the metal billet into the container for forming;

the step of pushing the boring punch into the metal billet and hot-dilating the metal billet so as to form the bottomed container where the bottom section and the body section are integral; and

the step of removing the pillar-shaped member from the bottom section of the bottomed container after the forming.

Claim 160 (Withdrawn): The method of manufacturing a container according to claim 154, wherein the body section of the container for forming can move relatively with respect to the bottom section of the container for forming.

Claim 161 (Withdrawn): The method of manufacturing a container according to claim 160, wherein the body section of the container for forming is divided in an axial direction.

Claim 162 (Withdrawn): A method of manufacturing a drum or a container of setting a metal billet into a container for forming and hot-dilating the metal billet by means of a boring punch to be operated by a pressing machine comprising:

the step of setting the metal billet, where its pressing forward side has a section having an outer diameter with a diagonal length of not more than an inner diameter of the container and its backward side has a section having an outer diameter substantially equal with the inner diameter of the container, into a container for press forming which was heated to a press working temperature; and

the step of boring a center of a workpiece of the metal billet by means of the boring punch and simultaneously press-working the metal billet.

Claim 163 (Withdrawn): The method of manufacturing a container according to claim 162, further comprising the step of forming the metal billet by means of a forging step and forming at least the pressing forward side of the metal billet into an angular section.

Claim 164 (Withdrawn): The method of manufacturing a container according to claim 163, wherein the forging step includes the step of providing a taper which becomes thinner towards the pressing direction on the pressing forward side of the metal billet.

Claim 165 (Withdrawn): The method of manufacturing a container according to claim 163, wherein the forging step includes the step of providing at least one stepped section so that the pressing forward side of the metal billet becomes thinner gradationally towards the pressing direction.

Claim 166 (Withdrawn): The method of manufacturing a container according to claim 162, further comprising:

the step of providing a drum-shaped member between the metal billet and the bottom of the container for forming and setting the metal billet into the container for forming;

the step of pushing the boring punch into the metal billet and hot-dilating the metal billet so as to form the bottomed container where the bottom section and the body section are integral;

the step of removing the drum-shaped member from the bottom section of the bottomed container after the forming; and

the step of removing a pillar-shaped portion formed on the bottom section of the bottomed container by means of the drum-shaped member.

Claim 167 (Withdrawn): The method of manufacturing a container according to claim 162, further comprising:

the step of providing a pillar-shaped member between the metal billet and the bottom of the container for forming and setting the metal billet into the container for forming;

the step of pushing the boring punch into the metal billet and hot-dilating the metal billet so as to form the bottomed container where the bottom section and the body section are integral; and

the step of removing the pillar-shaped member from the bottom section of the bottomed container after the forming.

Claim 168 (Withdrawn): The method of manufacturing a container according to claim 162, wherein the body section of the container for forming can move relatively with respect to the bottom section of the container for forming.

Claim 169 (Withdrawn): The method of manufacturing a container according to claim 168, wherein the body section of the container for forming is divided in an axial direction.

Claim 170 (Withdrawn): A method of manufacturing a drum or a container of setting a metal billet into a container for forming and hot-dilating the metal billet by means of a boring punch to be operated by a pressing machine, the method comprising:

the step of setting the metal billet, where its pressing forward side has a section having an outer diameter with a diagonal length of smaller than an inner diameter of the container and its backward side has a section having a diagonal length substantially equal

with the inner diameter of the container, into a container for press forming which was heated to a press working temperature; and

the step of boring a center of a workpiece of the metal billet by means of the punch and simultaneously press-working the metal billet.

Claim 171 (Withdrawn): The method of manufacturing a container according to claim 170, further comprising the step of forming the metal billet by means of a forging step and forming at least the pressing forward side of the metal billet into an angular section.

Claim 172 (Withdrawn): The method of manufacturing a container according to claim 171, wherein the forging step includes the step of providing a taper which becomes thinner towards the pressing direction on the pressing forward side of the metal billet.

Claim 173 (Withdrawn): The method of manufacturing a container according to claim 171, wherein the forging step includes the step of providing at least one stepped section so that the pressing forward side of the metal billet becomes thinner gradationally towards the pressing direction.

Claim 174 (Withdrawn): The method of manufacturing a container according to claim 170, further comprising:

the step of providing a drum-shaped member between the metal billet and the bottom of the container for forming and setting the metal billet into the container for forming;

the step of pushing the boring punch into the metal billet and hot-dilating the metal billet so as to form the bottomed container where the bottom section and the body section are integral;

the step of removing the drum-shaped member from the bottom section of the bottomed container after the forming; and

the step of removing a pillar-shaped portion formed on the bottom section of the bottomed container by means of the drum-shaped member.

Claim 175 (Withdrawn): The method of manufacturing a container according to claim 170, further comprising:

the step of providing a pillar-shaped member between the metal billet and the bottom of the container for forming and setting the metal billet into the container for forming;

the step of pushing the boring punch into the metal billet and hot-dilating the metal billet so as to form the bottomed container where the bottom section and the body section are integral; and

the step of removing the pillar-shaped member from the bottom section of the bottomed container after the forming.

Claim 176 (Withdrawn): The method of manufacturing a container according to claim 170, wherein the body section of the container for forming can move relatively with respect to the bottom section of the container for forming.

Claim 177 (Withdrawn): The method of manufacturing a container according to claim 176, wherein the body section of the container for forming is divided in an axial direction.

Claim 178 (Withdrawn): A method of manufacturing a drum or a container of setting a metal billet into a container for forming and hot-dilating the metal billet by means of a boring punch to be operated by a pressing machine, the method comprising:

the step of setting the metal billet, where its pressing forward side has a section with an outer diameter smaller than an inner diameter of the container and its backward side has a section with an outer diameter substantially equal with the inner diameter of the container, into a container for press forming which was heated to a press working temperature; and

the step of boring a center of a workpiece of the metal billet by means of the punch and simultaneously press-working the metal billet.

Claim 179 (Withdrawn): The method of manufacturing a container according to claim 178, further comprising the step of forming the metal billet by means of a forging step and forming at least the pressing forward side of the metal billet into an angular section.

Claim 180 (Withdrawn): The method of manufacturing a container according to claim 179, wherein the forging step includes the step of providing a taper which becomes thinner towards the pressing direction on the pressing forward side of the metal billet.

Claim 181 (Withdrawn): The method of manufacturing a container according to claim 179, wherein the forging step includes the step of providing at least one stepped section so that the pressing forward side of the metal billet becomes thinner gradationally towards the pressing direction.

Claim 182 (Withdrawn): The method of manufacturing a container according to claim 178, further comprising:

the step of providing a drum-shaped member between the metal billet and the bottom of the container for forming and setting the metal billet into the container for forming;

the step of pushing the boring punch into the metal billet and hot-dilating the metal billet so as to form the bottomed container where the bottom section and the body section are integral;

the step of removing the drum-shaped member from the bottom section of the bottomed container after the forming; and

the step of removing a pillar-shaped portion formed on the bottom section of the bottomed container by means of the drum-shaped member.

Claim 183 (Withdrawn): The method of manufacturing a container according to claim 178, further comprising:

the step of providing a pillar-shaped member between the metal billet and the bottom of the container for forming and setting the metal billet into the container for forming;

the step of pushing the boring punch into the metal billet and hot-dilating the metal billet so as to form the bottomed container where the bottom section and the body section are integral; and

the step of removing the pillar-shaped member from the bottom section of the bottomed container after the forming.

Claim 184 (Withdrawn): The method of manufacturing a container according to claim 178, wherein the body section of the container for forming can move relatively with respect to the bottom section of the container for forming.

Claim 185 (Withdrawn): The method of manufacturing a container according to claim 184, wherein the body section of the container for forming is divided in an axial direction.

Claim 186 (Withdrawn): A method of manufacturing a container, comprising:

the step of setting a metal billet having at least one plane on a side surface into a container for forming with a gap from an inner wall;

the step of pushing the metal billet so as to extend a pressing backward side of the metal billet to an end portion of an inlet of the container for forming; and

the step of pushing a boring punch into the metal billet and bending the plane towards the inner wall so as to hot-dilate the metal billet.

Claim 187 (Withdrawn): The method of manufacturing a container according to claim 186, further comprising the step of forming the metal billet by means of a forging step and forming at least the pressing forward side of the metal billet into an angular section.

Claim 188 (Withdrawn): The method of manufacturing a container according to claim 187, wherein the forging step includes the step of providing a taper which becomes thinner towards the pressing direction on the pressing forward side of the metal billet.

Claim 189 (Withdrawn): The method of manufacturing a container according to claim 187, wherein the forging step includes the step of providing at least one stepped section so that the pressing forward side of the metal billet becomes thinner gradationally towards the pressing direction.

Claim 190 (Withdrawn): The method of manufacturing a container according to claim 186, further comprising:

the step of providing a drum-shaped member between the metal billet and the bottom of the container for forming and setting the metal billet into the container for forming;

the step of pushing the boring punch into the metal billet and hot-dilating the metal billet so as to form the bottomed container where the bottom section and the body section are integral;

the step of removing the drum-shaped member from the bottom section of the bottomed container after the forming; and

the step of removing a pillar-shaped portion formed on the bottom section of the bottomed container by means of the drum-shaped member.

Claim 191 (Withdrawn): The method of manufacturing a container according to claim 186, further comprising:

the step of providing a pillar-shaped member between the metal billet and the bottom of the container for forming and setting the metal billet into the container for forming;

the step of pushing the boring punch into the metal billet and hot-dilating the metal billet so as to form the bottomed container where the bottom section and the body section are integral; and

the step of removing the pillar-shaped member from the bottom section of the bottomed container after the forming.

Claim 192 (Withdrawn): The method of manufacturing a container according to claim 186, wherein the body section of the container for forming can move relatively with respect to the bottom section of the container for forming.

Claim 193 (Withdrawn): The method of manufacturing a container according to claim 192, wherein the body section of the container for forming is divided in an axial direction.

Claim 194 (Withdrawn): A method of manufacturing a container, comprising:

the step of setting a metal billet, where at least one plane is provided on a side surface and an extended section engaging with an end portion of an inlet of a container for forming is provided on a pressing backward side, into a container for forming with a gap from an inner wall; and

the step of pushing a boring punch into the metal billet and bending the plane towards the inner wall so as to hot-dilate the metal billet.

Claim 195 (Withdrawn): The method of manufacturing a container according to claim 194, further comprising the step of forming the metal billet by means of a forging step and forming at least the pressing forward side of the metal billet into an angular section.

Claim 196 (Withdrawn): The method of manufacturing a container according to claim 195, wherein the forging step includes the step of providing a taper which becomes thinner towards the pressing direction on the pressing forward side of the metal billet.

Claim 197 (Withdrawn): The method of manufacturing a container according to claim 195, wherein the forging step includes the step of providing at least one stepped section so that the pressing forward side of the metal billet becomes thinner gradationally towards the pressing direction.

Claim 198 (Withdrawn): The method of manufacturing a container according to claim 194, further comprising:

the step of providing a drum-shaped member between the metal billet and the bottom of the container for forming and setting the metal billet into the container for forming;

the step of pushing the boring punch into the metal billet and hot-dilating the metal billet so as to form the bottomed container where the bottom section and the body section are integral;

the step of removing the drum-shaped member from the bottom section of the bottomed container after the forming; and

the step of removing a pillar-shaped portion formed on the bottom section of the bottomed container by means of the drum-shaped member.

Claim 199 (Withdrawn): The method of manufacturing a container according to claim 194, further comprising:

the step of providing a pillar-shaped member between the metal billet and the bottom of the container for forming and setting the metal billet into the container for forming;

the step of pushing the boring punch into the metal billet and hot-dilating the metal billet so as to form the bottomed container where the bottom section and the body section are integral; and

the step of removing the pillar-shaped member from the bottom section of the bottomed container after the forming.

Claim 200 (Withdrawn): The method of manufacturing a container according to claim 194, wherein the body section of the container for forming can move relatively with respect to the bottom section of the container for forming.

Claim 201 (Withdrawn): The method of manufacturing a container according to claim 200, wherein the body section of the container for forming is divided in an axial direction.

Claim 202 (Withdrawn): A method of manufacturing a container, comprising:

the step of setting a metal billet, where at least a section vertical to an axial direction on a pressing forward side is formed into a polygonal shape, into a container for forming;

the step of pushing the metal billet so as to extend a pressing backward side of the metal billet to an end portion of an inlet of the container for forming; and

the step of pushing a boring punch into the metal billet so as to hot-dilate the metal billet.

Claim 203 (Withdrawn): The method of manufacturing a container according to claim 202, further comprising the step of forming the metal billet by means of a forging step and forming at least the pressing forward side of the metal billet into an angular section.

Claim 204 (Withdrawn): The method of manufacturing a container according to claim 203, wherein the forging step includes the step of providing a taper which becomes thinner towards the pressing direction on the pressing forward side of the metal billet.

Claim 205 (Withdrawn): The method of manufacturing a container according to claim 203, wherein the forging step includes the step of providing at least one stepped section so that the pressing forward side of the metal billet becomes thinner gradationally towards the pressing direction.

Claim 206 (Withdrawn): The method of manufacturing a container according to claim 202, further comprising:

the step of providing a drum-shaped member between the metal billet and the bottom of the container for forming and setting the metal billet into the container for forming;

the step of pushing the boring punch into the metal billet and hot-dilating the metal billet so as to form the bottomed container where the bottom section and the body section are integral;

the step of removing the drum-shaped member from the bottom section of the bottomed container after the forming; and

the step of removing a pillar-shaped portion formed on the bottom section of the bottomed container by means of the drum-shaped member.

Claim 207 (Withdrawn): The method of manufacturing a container according to claim 202, further comprising:

the step of providing a pillar-shaped member between the metal billet and the bottom of the container for forming and setting the metal billet into the container for forming;

the step of pushing the boring punch into the metal billet and hot-dilating the metal billet so as to form the bottomed container where the bottom section and the body section are integral; and

the step of removing the pillar-shaped member from the bottom section of the bottomed container after the forming.

Claim 208 (Withdrawn): The method of manufacturing a container according to claim 202, wherein the body section of the container for forming can move relatively with respect to the bottom section of the container for forming.

Claim 209 (Withdrawn): The method of manufacturing a container according to claim 208, wherein the body section of the container for forming is divided in an axial direction.

Claim 210 (Withdrawn): A method of manufacturing a container, comprising:

the step of setting a metal billet, where at least one plane is provided on at least any one of a side surface of a pressing forward side and a side surface of a pressing backward side, into a container for forming;

the step of pushing the metal billet so as to extend a pressing backward side of the metal billet to an end portion of an inlet of the container for forming; and

the step of pushing a boring punch into the metal billet so as to hot-dilate the metal billet.

Claim 211 (Withdrawn): The method of manufacturing a container according to claim 210, further comprising the step of forming the metal billet by means of a forging step and forming at least the pressing forward side of the metal billet into an angular section.

Claim 212 (Withdrawn): The method of manufacturing a container according to claim 211, wherein the forging step includes the step of providing a taper which becomes thinner towards the pressing direction on the pressing forward side of the metal billet.

Claim 213 (Withdrawn): The method of manufacturing a container according to claim 211, wherein the forging step includes the step of providing at least one stepped section so that the pressing forward side of the metal billet becomes thinner gradationally towards the pressing direction.

Claim 214 (Withdrawn): The method of manufacturing a container according to claim 210, further comprising:

the step of providing a drum-shaped member between the metal billet and the bottom of the container for forming and setting the metal billet into the container for forming;

the step of pushing the boring punch into the metal billet and hot-dilating the metal billet so as to form the bottomed container where the bottom section and the body section are integral;

the step of removing the drum-shaped member from the bottom section of the bottomed container after the forming; and

the step of removing a pillar-shaped portion formed on the bottom section of the bottomed container by means of the drum-shaped member.

Claim 215 (Withdrawn): The method of manufacturing a container according to claim 210, further comprising:

the step of providing a pillar-shaped member between the metal billet and the bottom of the container for forming and setting the metal billet into the container for forming;

the step of pushing the boring punch into the metal billet and hot-dilating the metal billet so as to form the bottomed container where the bottom section and the body section are integral; and

the step of removing the pillar-shaped member from the bottom section of the bottomed container after the forming.

Claim 216 (Withdrawn): The method of manufacturing a container according to claim 210, wherein the body section of the container for forming can move relatively with respect to the bottom section of the container for forming.

Claim 217 (Withdrawn): The method of manufacturing a container according to claim 216, wherein the body section of the container for forming is divided in an axial direction.

Claim 218 (Withdrawn): A method of hot pressing a thick metal-made cylinder or a cylindrical container having an excellent shape of an end surface, wherein a metal billet having different diameter sections without joint, where its pressing forward side is composed of a member having a section with an outer diameter smaller than an inner diameter of a container or an outer diameter of a diagonal length or a member having a section with an outer diameter of a diagonal length equal with the inner diameter of the container and its backward side is composed of a member having a section with an outer diameter or a diagonal length equal with the inner diameter of the container, is set into the container for press forming which was heated to a press working temperature, and the metal billet is pushed so that the pressing backward side of the metal billet is extended to an end portion of

an inlet of the container for forming, and while a center of a workpiece of the metal billet without joint is being bored by a punch, the metal billet is press-worked.

Claim 219 (Withdrawn): The method of manufacturing a container according to claim 218, further comprising the step of forming the metal billet by means of a forging step and forming at least the pressing forward side of the metal billet into an angular section.

Claim 220 (Withdrawn): The method of manufacturing a container according to claim 219, wherein the forging step includes the step of providing a taper which becomes thinner towards the pressing direction on the pressing forward side of the metal billet.

Claim 221 (Withdrawn): The method of manufacturing a container according to claim 219, wherein the forging step includes the step of providing at least one stepped section so that the pressing forward side of the metal billet becomes thinner gradationally towards the pressing direction.

Claim 222 (Withdrawn): The method of manufacturing a container according to claim 218, further comprising:

the step of providing a drum-shaped member between the metal billet and the bottom of the container for forming and setting the metal billet into the container for forming;

the step of pushing the boring punch into the metal billet and hot-dilating the metal billet so as to form the bottomed container where the bottom section and the body section are integral;

the step of removing the drum-shaped member from the bottom section of the bottomed container after the forming; and

the step of removing a pillar-shaped portion formed on the bottom section of the bottomed container by means of the drum-shaped member.

Claim 223 (Withdrawn): The method of manufacturing a container according to claim 218, further comprising:

the step of providing a pillar-shaped member between the metal billet and the bottom of the container for forming and setting the metal billet into the container for forming;

the step of pushing the boring punch into the metal billet and hot-dilating the metal billet so as to form the bottomed container where the bottom section and the body section are integral; and

the step of removing the pillar-shaped member from the bottom section of the bottomed container after the forming.

Claim 224 (Withdrawn): The method of manufacturing a container according to claim 218, wherein the body section of the container for forming can move relatively with respect to the bottom section of the container for forming.

Claim 225 (Withdrawn): The method of manufacturing a container according to claim 224, wherein the body section of the container for forming is divided in an axial direction.

Claim 226 (Withdrawn): A method of manufacturing a drum or a container of setting a metal billet into a container for forming and hot-dilating the metal billet by means of a boring punch to be operated by a pressing machine, the method comprising:

the step of setting the metal billet, where its pressing forward side has a section having an outer diameter with a diagonal length of not more than an inner diameter of the container and its backward side has a section having an outer diameter substantially equal with the inner diameter of the container, into a container for press forming which was heated to a press working temperature;

the step of pushing the metal billet so as to extend the pressing backward side of the metal billet to an end portion of an inlet of the container for forming; and

the step of boring a center of a workpiece of the metal billet by means of the boring punch and simultaneously press-working the metal billet.

Claim 227 (Withdrawn): The method of manufacturing a container according to claim 226, further comprising the step of forming the metal billet by means of a forging step and forming at least the pressing forward side of the metal billet into an angular section.

Claim 228 (Withdrawn): The method of manufacturing a container according to claim 227, wherein the forging step includes the step of providing a taper which becomes thinner towards the pressing direction on the pressing forward side of the metal billet.

Claim 229 (Withdrawn): The method of manufacturing a container according to claim 227, wherein the forging step includes the step of providing at least one stepped section so that the pressing forward side of the metal billet becomes thinner gradationally towards the pressing direction.

Claim 230 (Withdrawn): The method of manufacturing a container according to claim 226, further comprising:

the step of providing a drum-shaped member between the metal billet and the bottom of the container for forming and setting the metal billet into the container for forming;

the step of pushing the boring punch into the metal billet and hot-dilating the metal billet so as to form the bottomed container where the bottom section and the body section are integral;

the step of removing the drum-shaped member from the bottom section of the bottomed container after the forming; and

the step of removing a pillar-shaped portion formed on the bottom section of the bottomed container by means of the drum-shaped member.

Claim 231 (Withdrawn): The method of manufacturing a container according to claim 226, further comprising:

the step of providing a pillar-shaped member between the metal billet and the bottom of the container for forming and setting the metal billet into the container for forming;

the step of pushing the boring punch into the metal billet and hot-dilating the metal billet so as to form the bottomed container where the bottom section and the body section are integral; and

the step of removing the pillar-shaped member from the bottom section of the bottomed container after the forming.

Claim 232 (Withdrawn): The method of manufacturing a container according to claim 226, wherein the body section of the container for forming can move relatively with respect to the bottom section of the container for forming.

Claim 233 (Withdrawn): The method of manufacturing a container according to claim 232, wherein the body section of the container for forming is divided in an axial direction.

Claim 234 (Withdrawn): A method of manufacturing a drum or a container of setting a metal billet into a container for forming and hot-dilating the metal billet by means of a boring punch to be operated by a pressing machine, the method comprising:

the step of setting the metal billet, where its pressing forward side has a section having an outer diameter with a diagonal length of smaller than an inner diameter of the container and its backward side has a section having a diagonal length substantially equal with the inner diameter of the container, into a container for press forming which was heated to a press working temperature;

the step of pushing the metal billet so as to extend the pressing backward side of the metal billet to an end portion of an inlet of the container for forming; and

the step of boring a center of a workpiece of the metal billet by means of the punch and simultaneously press-working the metal billet.

Claim 235 (Withdrawn): The method of manufacturing a container according to claim 234, further comprising the step of forming the metal billet by means of a forging step and forming at least the pressing forward side of the metal billet into an angular section.

Claim 236 (Withdrawn): The method of manufacturing a container according to claim 235, wherein the forging step includes the step of providing a taper which becomes thinner towards the pressing direction on the pressing forward side of the metal billet.

Claim 237 (Withdrawn): The method of manufacturing a container according to claim 235, wherein the forging step includes the step of providing at least one stepped section so that the pressing forward side of the metal billet becomes thinner gradationally towards the pressing direction.

Claim 238 (Withdrawn): The method of manufacturing a container according to claim 234, further comprising:

the step of providing a drum-shaped member between the metal billet and the bottom of the container for forming and setting the metal billet into the container for forming;

the step of pushing the boring punch into the metal billet and hot-dilating the metal billet so as to form the bottomed container where the bottom section and the body section are integral;

the step of removing the drum-shaped member from the bottom section of the bottomed container after the forming; and

the step of removing a pillar-shaped portion formed on the bottom section of the bottomed container by means of the drum-shaped member.

Claim 239 (Withdrawn): The method of manufacturing a container according to claim 234, further comprising:

the step of providing a pillar-shaped member between the metal billet and the bottom of the container for forming and setting the metal billet into the container for forming;

the step of pushing the boring punch into the metal billet and hot-dilating the metal billet so as to form the bottomed container where the bottom section and the body section are integral; and

the step of removing the pillar-shaped member from the bottom section of the bottomed container after the forming.

Claim 240 (Withdrawn): The method of manufacturing a container according to claim 234, wherein the body section of the container for forming can move relatively with respect to the bottom section of the container for forming.

Claim 241 (Withdrawn): The method of manufacturing a container according to claim 240, wherein the body section of the container for forming is divided in an axial direction.

Claim 242 (Withdrawn): A method of manufacturing a drum or a container of setting a metal billet into a container for forming and hot-dilating the metal billet by means of a boring punch to be operated by a pressing machine, the method comprising:

the step of setting the metal billet, where its pressing forward side has a section with an outer diameter smaller than an inner diameter of the container and its backward side has a section with an outer diameter substantially equal with the inner diameter of the container, into a container for press forming which was heated to a press working temperature;

the step of pushing the metal billet so as to extend the pressing backward side of the metal billet to an end portion of an inlet of the container for forming; and

the step of boring a center of a workpiece of the metal billet by means of the punch and simultaneously press-working the metal billet.

Claim 243 (Withdrawn): The method of manufacturing a container according to claim 242, further comprising the step of forming the metal billet by means of a forging step and forming at least the pressing forward side of the metal billet into an angular section.

Claim 244 (Withdrawn): The method of manufacturing a container according to claim 243, wherein the forging step includes the step of providing a taper which becomes thinner towards the pressing direction on the pressing forward side of the metal billet.

Claim 245 (Withdrawn): The method of manufacturing a container according to claim 243, wherein the forging step includes the step of providing at least one stepped section so that the pressing forward side of the metal billet becomes thinner gradationally towards the pressing direction.

Claim 246 (Withdrawn): The method of manufacturing a container according to claim 242, further comprising:

the step of providing a drum-shaped member between the metal billet and the bottom of the container for forming and setting the metal billet into the container for forming;

the step of pushing the boring punch into the metal billet and hot-dilating the metal billet so as to form the bottomed container where the bottom section and the body section are integral;

the step of removing the drum-shaped member from the bottom section of the bottomed container after the forming; and

the step of removing a pillar-shaped portion formed on the bottom section of the bottomed container by means of the drum-shaped member.

Claim 247 (Withdrawn): The method of manufacturing a container according to claim 242, further comprising:

the step of providing a pillar-shaped member between the metal billet and the bottom of the container for forming and setting the metal billet into the container for forming;

the step of pushing the boring punch into the metal billet and hot-dilating the metal billet so as to form the bottomed container where the bottom section and the body section are integral; and

the step of removing the pillar-shaped member from the bottom section of the bottomed container after the forming.

Claim 248 (Withdrawn): The method of manufacturing a container according to claim 242, wherein the body section of the container for forming can move relatively with respect to the bottom section of the container for forming.

Claim 249 (Withdrawn): The method of manufacturing a container according to claim 248, wherein the body section of the container for forming is divided in an axial direction.

Claim 250 (Withdrawn): A method of manufacturing a container comprising:

the upsetting step of placing a pressurizing platform into a ring-shaped die formed with an opening at its inner end portion and putting a metal billet into a mold composed of the die and the pressurizing platform so as to pressurize the metal billet by means of a boring punch; and

the metal billet drawing step of supporting the die by means of a drum-shaped spacer and pushing the metal billet by means of the boring punch.

Claim 251 (Withdrawn): A method of manufacturing a container comprising:

the upsetting preparation step of stacking a plurality of ring-shaped dies formed with an opening on its inner end portion and stacking a plurality of pressurizing platforms respectively in the dies and putting a metal billet into a mold composed of the die and the pressurizing platform;

the upsetting step of pressurizing the metal billet from above the mold using a boring punch to be operated by a pressing machine;

the receding step of allowing the boring punch and the whole metal billet including and the upper die to recede;

the drawing preparation step of removing the used pressurizing platform and placing a drum-shaped spacer onto the next die and placing the receded whole metal billet including the die onto the spacer;

the drawing step of pushing the metal billet by means of the boring punch and drawing the metal billet by means of the die; and

the repeating step of repeating the above-mentioned steps on the next pressurizing platform and die using a spacer of a length according to deformation of the metal billet.